

Date: Friday, 29/08/2008 11:39:05 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 41676		Part Number	: D28105		
Estimate Number	: 11044		Drawing Number	: D2810 / D2727		
P.O. Number	:		Project Number	: N/A		
This Issue	: 29/08/2008 S.O. No. :		Drawing Revision	: C / A1		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : MACHINED PARTS		Due Date	: 08/09/2008 Qty: 10 Um: Each		
Previous Run	: 41029					
Written By	:					
Checked & Approved By	: JUN 08.8.29					
Comment	: Est. A 04.11.30 New issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 2.1000 f(s)/Unit Total : 21.0000 f(s) 304 RD Tube .500 x .035W Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 Batch: M 108 202	
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 2-Deburr	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	 Soslub6 (x10)
4.0	POWDER COATING	POWDER COATING	
		 M 10 5 642	 (10x)
		Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	
	START TIME:	8-00	
	OVEN TEMPERATURE:	320° F	
	FINISH TIME:	8-30	
			m-1 08/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

FZ 08/11/27

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 265

88 08/11/27 (X)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/01 88

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

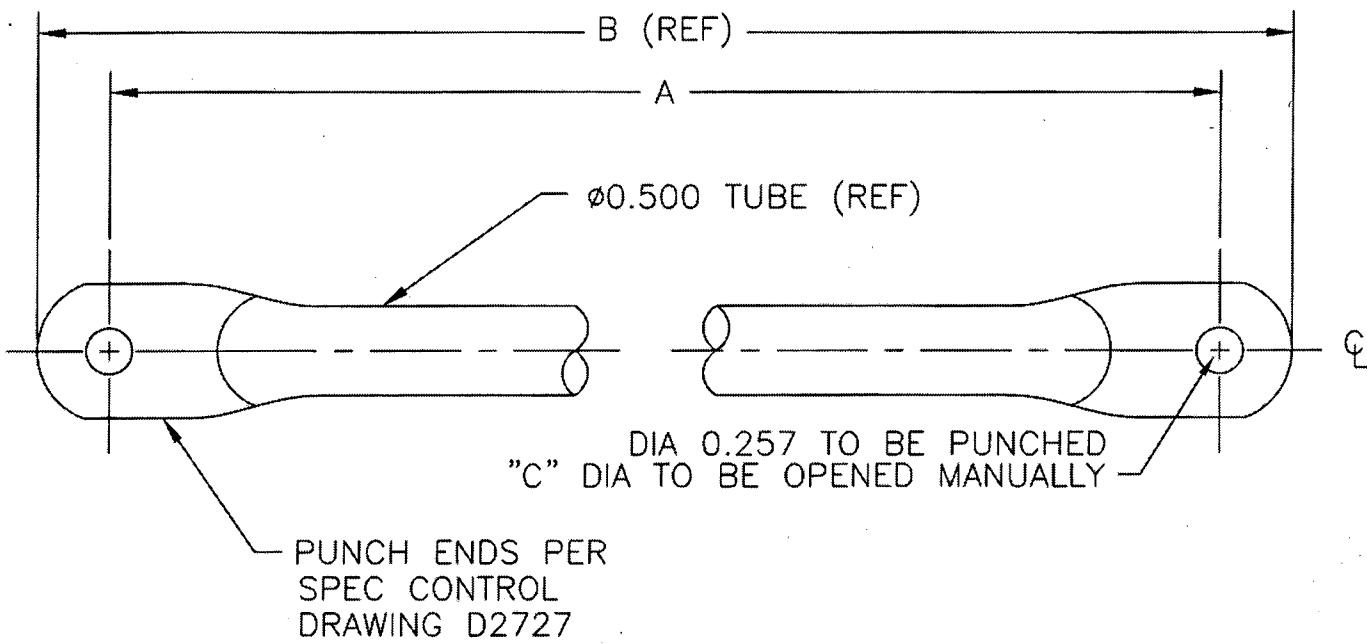
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2810
DATE		REV. C SHEET 1 OF 1
04.11.22		TITLE STRUT
		SCALE NTS

RELEASED

05-03-14



PART #	A	B	C
D2810-1	25.33	26.13	N/A
D2810-3	24.60	25.40	N/A
D2810-5	23.01	23.81	0.266

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44670

D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.500 x 0.035 WALL (M304TR0.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

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